Work Orde January-30-14 1		578		*112	2578°	*						Page 1	
Revision ID:	D3601-1			Accept	*N9	იი	040	100)* s	Setup Star	171	S1*	
		Start Qty: 60.00 Req'd Qty: 60.00	` '''		Cust Custo	Item I omer:	D: .			540	[₽] *N	S2*	
	Process Plan: QC:	•	Date: 14-01-0				ate:		F	Run Sta Sto	~1 <i>7</i> 1	R1* R2*	
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D3601	Rev A												
100 *100* Shear	S	HEAR Memo blanks 9.00	0" long +/- 0.030"Note: 1 b	0.00 0.00 lank makes 8 pieces					10	þ		DR 14-03-	19
110 *110* HAAS 1 HAAS CNC vertical		IAAS CNC VERTICA Memo 1- Mill as _l	NL MACHINING #1 per Folio FA682 Rev: <u>AA</u>	0.00 0.00 _ & Dwg D3601 Rev:	<u> </u>				75	<u>ø</u>	·	[R14-03.	-L
120 *1 20* QC	C	2C2- Inspect parts off Memo	machine FAI/FAIB	0.00					75	J		13/14-03	? ~/

Quality Control

r: _		Date:			WORK ORDER NON-		3 PM In 1 PM	MANCE/III	DDATE			
r: _	****						NITO	MINIMITEL / OI		/ork Order up	date only	AEROSPACE
· –					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
o					Rework Scrap Use-as-is Suspected Unapproved		Therm	Machining noforming	Crosstube Small Fab Finishing Composite	-	_	Engineering Quality Other
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	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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Work Orde						*11	2578	*							Page 2
Revision ID:	D3601-1 Radius Block		V (1)		F	Accept	*N9	ററ	040	100)*	Setup	Start Stop		S1*
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¹³⁰ *1.30*		QC8- Inspec	et parts - secon	id check		0.00	onl 14	1031	20		マケ	_	es		DAS 14 9-89
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DQA:			Date:					·					`	TRAC
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	ndate only	_	AEROSPACE
an closeu.			Dute.			DISPOSITION			ACAINCT		PARTMENT			
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Part N	- ا اه					Rework Scrap			Skid-tube Crosstube Machining Small Fab	-	· Pro	Water Jet d. Eng. Coor.		Engineering Quality
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	\perp	QC Inspector
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		Bending			L	Bend		Folio/f	Program	L	Outside Dim	ensions		Pressure/Forced
		Centre N	ot Concer	ntric	L	BOM/Route		Grain			Over/Under	tolerance	_	Set-up
		Cracks				Broken/Damage/Defect	L	Hardwa	are	L	Part Incorre	ci _		Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified	L	Part Lost/M	issing	_	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved	Ĺ		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned \	Wrong		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	'Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	vist in Tuk	эe		Fit/Function		Out of	Sequence					

Work Ord				*11	2578°	*						Page 3
Item ID: Revision ID:	D3601-1			Accept	*N9	იიი4(110 0)*	Setup	Start Stop	171	S1*
Item Name: Start Date: Required Date: Reference:	Radius Block 1/30/14 : 1/30/14	Start Qty: 60.00 Req'd Qty: 60.00	*60* *60*		Cust l Custo	Item ID: mer:					···IVI	S2*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop	^I/J	R1* R2*
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	DAS 27 9-89	ID Tool	# Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & Stoc Memo	ck Location: \$5	0.00				76	DAS 06 9-89		MA [*]	R 2 5 2014

180

QC21- Final Inspection - Work Order Release

0.00

120

Memo

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Quality Control

MLJ 1403-26 MLJ 1403-25

DQA:			Date:			WORK ORDER NON-	.cc	ONFOE	RMANCE / LI	PDATE			DART
QA Closed:			Date:			WORK ORDER HOR)	WANTED / O		ork Order up	date only	AEROSPACE
Work Orde	or.					DISPOSITION		i	····	AGAINST DI	PARTMENT	/PROCESS	
Work Orac	- ' -					Rework	ı		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	10.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR I	۱o.					Suspected Unapproved			Large Fab	Composite	_	Supplier	
Root					Desci	ription of work order update	Ī	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Landi	ng (Gear				General							
i		Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
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		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ci	Temperature/Cure
ļ.		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified	Part Lost/Mi	issing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_
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l		Inspectio	n Strip in	Tube		Drawing		Misrea	t				
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		Turning S				Finish		Out of	Calibration				
		Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence				

January-30-14 11:50:25 AM

Work Order ID:

112578

Parent Item:

D3601-1

Parent Item Name:

Radius Block

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A New Issue 07-03-28 JLM

0011111011													
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.125	•	Purchased	No				f	90.5500		3.996	[1	
6061-T6 Bar .750 x .125												<u> </u>	100
				Location		Loc Qty	Lo	c Code			14	1-03-	19
				MAT049		90.55							
•				M12	27818	90.55	1		7.5	525-12.			

DQA:			Date:	<u> </u>									DART
QA Closed:			Date:			WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
<u> </u>						DISPOSITION			AGAINS		PARTMENT		
Work Orde	er: _		-11				. 1			_	1	_	
•						Rework			Skid-tube Crosstub			Water Jet	Engineering
Part N	10.					Scrap			Machining Small Fa		4	d. Eng. Coor.	Quality
NCD						Use-as-is		Therr	moforming Finishin	~—	Kec/Stol	re/Packaging Supplier	Other
NCR I	۱O. ₋					Suspected Unapproved			Large Fab Composit	ح	1	Supplier [
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design	\Box			-									-
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Landi	na G				**	General	17	OLI CA	TEOON!				
Land		Bending				Bend		Folio/	Program	Г	Outside Dim	ensions [Pressure/Forced
	-	Centre No	nt Concer	ntric		BOM/Route	\vdash	Grain		\vdash	Over/Under	├ ─	Set-up
		Cracks				Broken/Damage/Defect		Hardw	are	F	Part Incorre	<u> </u>	Temperature/Cure
	\vdash	Crimp/Kir	nk/Ripple	/Wave		Burrs		4	tion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs		•		Contamination	\vdash	1 '	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Г	Crushing				Countersink		4	gned/off center	Г	Positioned V		
		Heat Trea	at			Cut Too Short		Mislab	= '		Power Loss/	'Surge	Other
	Г	Inspectio	n Strip in	Tube		Drawing		Misrea	nd				-
	Г	Marks/Ch				Drill Holes		Off-set	t				
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tul	ре		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	1125+8
Description: Radius Block	Part Number:	D3601-1
Inspection Dwg: D3601 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

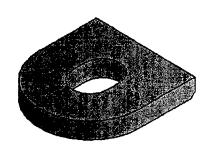
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.747	~		De 16	E'UEKD
0.375	+/-0.010	.374	_		1	1
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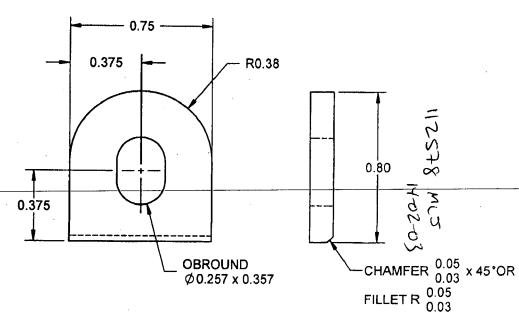
		DAS		
Measured by:	Audited by:	On 14	Preliminary Approval:	
Date: 14-03-19	Date:	14/03/21	Date:	

Rev	Date	Change	Revised by	Approved
Α	07.05.08	New Issue	KJ/JLM ,	
В	11.08.22	Dimensions updated	KJ 98	1 12



DESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED	APPROVED	DRAWING NO.	REV. A
07.02.13			RADIUS BLOCK	SCALE 2:1
REV			DESCRIPTION	
IAI		07 02 13	NEW/ISSUE	





D3601-1 RADIUS BLOCK

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX